

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006200**Date Inspected:** 12-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shi Lin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG segments**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG outside assembly 4BW

This QA observed ZPMC qualified welding personnel identified as 048617, 054467, 049769 and 048659 perform SMAW welding on weld joints identified as SEG019D-019~023, 028~032, 037~041, 046~050, 055~059, SEG019E-019~023, 042~046, 065~069, 074~078, 083~087, 092~096, 101~105, 110~114, 119~123, 128~132, 137~141, 146~150, 155~159, 164~168 and 173~177. ZPMC QC CWI identified as Mr. Shi Lin was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM.

OBG outside assembly 4BE, 3AE and 3BE

This QA observed ZPMC qualified welding personnel identified as 220068, 220064 and 220069 perform FCAW welding on weld joint identified as OBG3A-003. ZPMC QC identified as Mr. Zhang Hai Tao was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231T.

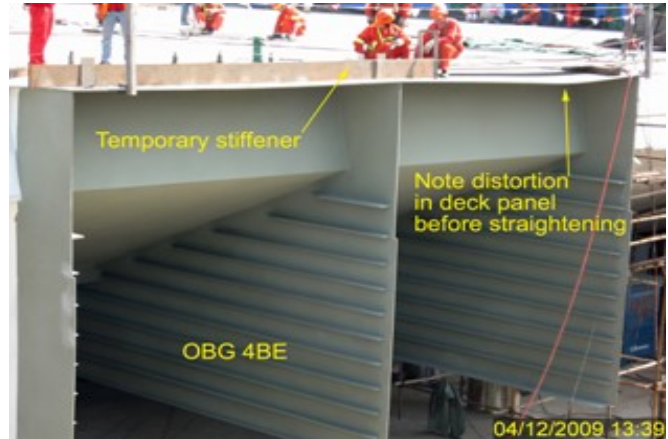
This QA observed that the contractor has performed material straightening without an approved straightening

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procedure. The contractor has attempted to straighten the deck plate on OBG segment by tack welding temporary stiffeners to the top side of the deck plates in the area of the crossbeams. The OBG segment and deck plate is identified as OBG segment 4BE deck panel DP047A. AWS D1.5 2002 section 3.1.5 prohibits welding on the material if no weld is detailed on the drawings and 3.7.3 requires engineers approval prior to straightening material distorted by welding. This QA notified ZPMC QA identified as Mr. Fu Yuhong and ABF QA inspector identified as Mr. Kevin Chen that an incident report would be forth coming concerning this issue.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

As mentioned above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By: Hall, Steven

Quality Assurance Inspector

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Reviewed By: Carreon,Albert

QA Reviewer